



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D2673-34**  
**Job Sheet 178555**



Part No: D2673-34

Job Qty: 40 ea

Part Name: End Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/1/18

Job Tracking No:

Due Date: ~~6/25/18~~ July 5

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP C 02.01.14 Removed deburr and inspect level 5 NG/EC IPP Rev:D Now 6061-T6 06-06-23  
JLM IPP Rev:C Now on Waterjet 07-05-28 JLM

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off           |
|-------|--------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|--------------------|
|       |                    |        |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                    |
| 90    | Start up Operation | 40 Ea  |            | 6/25/18  | 0.00      | 0.00    | Start Up Waterjet     |           | pc 18/06/07        |
| 100   | Waterjet           | 40 pcs |            | 6/25/18  | 0.01      | 0.66    | Waterjet1             |           | pc 18/06/07        |
| 120   | QC                 | 40 pcs |            | 6/25/18  | 0.00      | 0.00    | QC8                   |           | 38                 |
| 130   | Packaging          | 40 pcs |            | 6/25/18  | 0.00      | 0.00    | Packaging3            |           | pc 20/06-11        |
| 140   | QC21-SA            | 40 Ea  |            | 6/25/18  | 0.00      | 0.00    | QC21                  |           | DAS 21 JUN 11 2018 |

Part Op 100 - 1-Cut as per Dwg D2673  
Descriptions: 130 - LOCATION WA003

### Job BOM

| Part / Item  | Component Name     | Quantity            | Operation             | Container |
|--------------|--------------------|---------------------|-----------------------|-----------|
| M6061T6S.080 | 6061-T6 .080 Sheet | 2.0800 sf (.052 ea) | 90-Start up Operation | 5072722   |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | M6061T6S.080   | 2        | 183       | 0         |

### Part Specifications

| Spec No | Description | Target/Tolerance    | Limits         | Type   | Special Comments |
|---------|-------------|---------------------|----------------|--------|------------------|
| 1       | End Plate   | 3.300Inches ± 0.010 | 3.310<br>3.290 |        |                  |
| 2       | End Plate   | 2.247Inches ± 0.010 | 2.257<br>2.237 |        |                  |
| 3       | End Plate   | 0.250Inches ± 0.010 | 0.260<br>0.240 | Radius |                  |

Plex 6/1/18 1:52 PM Dart.lajeunesse.marie

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           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type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> |                                      |                                                                                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | Skid-tube <input type="checkbox"/> | Cross tube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |                  |                          |                          |                    |                          |                          |                     |                          |                          |                     |                          |                          |                       |                          |                          |                  |                                                                                                                                                                                                                                                                            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border: 1px solid #ccc;"></div> <div style="position: absolute; top: 0; left: 0; width: 100%; height: 100%; background-color: #101010; border: 1px solid #ccc;"></div> <div style="position: absolute; top: 0; left: 0; width: 100%; height: 100%; background-color: #000000; border: 1px solid #ccc;"></div> </div> <div style="position: absolute; top: 0; left: 0; width: 100%; height: 100%; pointer-events: none;"> <div style="position: absolute; top: 0; left: 0; width: 100%; height: 100%; background-color: #f0f0f0; border: 1px solid #ccc;"></div> <div style="position: absolute; top: 0; left: 0; width: 100%; height: 100%; background-color: #e0e0e0; border: 1px solid #ccc;"></div> <div style="position: absolute; top: 0; left: 0; width: 100%; height: 100%; background-color: #d0d0d0; border: 1px solid #ccc;"></div> <div style="position: absolute; top: 0; left: 0; width: 100%; height: 100%; background-color: #c0c0c0; border: 1px solid #ccc;"></div> <div style="position: absolute; top: 0; left: 0; 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   | <input type="checkbox"/>           | Supplier                                   | Handling/Pre                     | <input type="checkbox"/>               | Training                           | Material                                     | <input type="checkbox"/>       | Use for Testing                    | Internal Transport                 | <input type="checkbox"/>          | Poor Information | Tribal Knowledge         | <input type="checkbox"/> | Rushing            | LOA                      | <input type="checkbox"/> | Product Improvement | Substation               | <input type="checkbox"/> | Process Improvement | Past Expiry Date         | <input type="checkbox"/> | Manufacturing Process | Misidentified            | <input type="checkbox"/> | Past Due         | <div style="text-align: center;"> <br/> <b>Container No: S078838</b><br/> <br/> <b>Part: D2673 - 34</b><br/> <b>Job No: 178555</b><br/> <b>Serial No/Batch: S078838</b><br/>           Revision: _____<br/>           Inspector: _____<br/>           Exp Date: 06/07/2018<br/>           Instructions: _____         </div> | <table style="width:100%;"> <tr><td><input type="checkbox"/></td><td>Crimp/Kink/Ripple/Wave</td><td><input type="checkbox"/></td><td>Inspection Incomplete/Unqualified</td><td><input type="checkbox"/></td><td>Wrong Stock Picked</td></tr> <tr><td><input type="checkbox"/></td><td>Cuffs</td><td><input type="checkbox"/></td><td>Contamination</td><td><input type="checkbox"/></td><td>Out of Sequence</td></tr> <tr><td><input type="checkbox"/></td><td>Crushing</td><td><input type="checkbox"/></td><td>Countersink</td><td><input type="checkbox"/></td><td>Off-set</td></tr> <tr><td><input type="checkbox"/></td><td>Heat Treat</td><td><input type="checkbox"/></td><td>Cut Too Short</td><td><input type="checkbox"/></td><td>Mislabeled</td></tr> <tr><td><input type="checkbox"/></td><td>Wave/Twist in Tube</td><td><input type="checkbox"/></td><td>Instructions Incomplete/Unclear</td><td><input type="checkbox"/></td><td>Fit/Function</td></tr> <tr><td><input type="checkbox"/></td><td>Marks/Chatter</td><td><input type="checkbox"/></td><td>Drill Holes</td><td><input type="checkbox"/></td><td>Misaligned/off center</td></tr> </table> | <input type="checkbox"/> | Crimp/Kink/Ripple/Wave   | <input type="checkbox"/> | Inspection Incomplete/Unqualified                                                                                                                                                                                                                                                                                            | <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                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